



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-011
Job Sheet 180086



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev: I 09.25 IPP Rev: J 06-03-23 As per Rev D IPP Rev: K 06-07.13
As per dsi9343 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Ver: EC IPP Rev: M 08-04-22 DD
verified: EC IPP Rev: N 08-09-23 revF DD verified: ec IPP Rev: O 09-02-06 per PAR09-010 DD ver: EC IPP
Rev: P 10.06.22 revise seq110 DD ver: EC IPP Rev: Q 10.10.01 as per IIN revH DD ver: EC IPP Rev: R
13.08.27 PER ECN13-594 DD VER: JLM

Ship Via:

6405

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/26/18	7/26/18	0.00	0.00	Start Up Skidtubes-1		JL
110	Skidtubes	1 pcs	7/26/18	7/26/18	0.00	4.55	Skidtubes-4		BE DAS
120	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC10		38 DAS
130	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC5		38 DAS
140	HandFinish	1 pcs	7/26/18	7/26/18	0.00	0.93	HandFinish1		DR 18/10/13
150	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC7-2		MAG
160	Skidtubes	1 pcs	7/26/18	7/26/18	0.00	4.55	Skidtubes-4		MAG, BE, JL
170	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC10		38 DAS
180	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC5		38 DAS
190	HandFinish	1 pcs	7/26/18	7/26/18	0.00	0.93	HandFinish2		DR 18/11/05
200	SprayPaint	1 pcs	7/26/18	7/26/18	0.00	0.91	Spray Paint		Redd. BE
205	Outsource	1 pcs	7/26/18	7/26/18			ATE003-VC		NOV 08 2018
210	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC14		NOV 15 2018
230	HandFinish	1 pcs	7/26/18	7/26/18	0.00	0.93	HandFinish4		BE, BE, JL
240	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC5		NOV 09 2018
250	Packaging	1 pcs	7/26/18	7/26/18	0.00	0.00	Packaging1-3		NOV 12 2018
260	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC4		NOV 12 2018
270	Packaging	1 pcs	7/26/18	7/26/18	0.00	0.00	Packaging3-1		NOV 13 2018
275	DC	1 pcs	7/26/18	7/26/18	0.00	0.00	DC		NOV 13 2018
280	QC21-FG	1 Ea	7/26/18	7/26/18	0.00	0.00	QC21		NOV 13 2018

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750
sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4-
Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY
AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".
6-Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill
grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138073 8-Grind welds flush as per Dwg
D2750
160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg
D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float

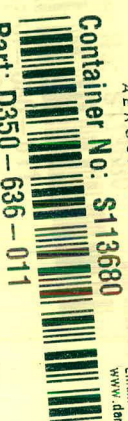
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐																																																																																																	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐																																																																																																	
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 Container No: S113680 Part: D350-636-011 Job No: 180086 Serial No/Batch: S113680 Revision: Inspector: Exp Date: Instructions: TC STC SH99-7 Issue 2 of 2, STA SR00646SI																																																																																																											
<table border="1"><thead><tr><th colspan="2">Root Cause</th></tr></thead><tbody><tr><td>Environment</td><td>☐</td></tr><tr><td>Design</td><td>☐</td></tr><tr><td>Doc/Data</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Pre</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Internal Transport</td><td>☐</td></tr><tr><td>Tribal Knowledge</td><td>☐</td></tr><tr><td>LOA</td><td>☐</td></tr><tr><td>Substation</td><td>☐</td></tr><tr><td>Past Expiry Date</td><td>☐</td></tr><tr><td>Misidentified</td><td>☐</td></tr></tbody></table> <table border="1"><tbody><tr><td>Rushing</td><td>☐</td><td>Crushing</td><td>☐</td><td>Confirmation</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td><td>Heat Treat</td><td>☐</td><td>Countersink</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td><td>Wave/Twist in Tube</td><td>☐</td><td>Cut Too Short</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td><td>Marks/Chatter</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td></tr><tr><td>Past Due</td><td>☐</td><td></td><td>☐</td><td>Drill Holes</td><td>☐</td></tr></tbody></table> <table border="1"><tbody><tr><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Audio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr><tr><td>Gain</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr><tr><td>Field</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr><tr><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr><tr><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr></tbody></table>												Root Cause		Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	Rushing	☐	Crushing	☐	Confirmation	☐	Product Improvement	☐	Heat Treat	☐	Countersink	☐	Process Improvement	☐	Wave/Twist in Tube	☐	Cut Too Short	☐	Manufacturing Process	☐	Marks/Chatter	☐	Instructions Incomplete/Unclear	☐	Past Due	☐		☐	Drill Holes	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Audio/Program	☐	Outside Dimensions	☐	Gain	☐	Over/Under tolerance	☐	Field	☐	Part Incorrect	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Out of Sequence	☐	Part Moved	☐	Off-set	☐	Drawing	☐	Mislabeled	☐	Finish	☐	Fit/Function	☐	Misread	☐	Misaligned/off center	☐	Turning Sequence	☐
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hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: M138943 exp. date: 11-03-06 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 138673 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

205 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2-

PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: POO41604

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M138943 EXP DATE: 11-03 4-

Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M138843 5- Coat all exposed fasteners with "LPS Procyon" batch: M133690.

260 - *****ensure antiseize is on AN8C21A bolts*****

270 - Package as per PPP D350-636-011 Location : FG072

275 - record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-011 CHG 007

M. H. 006353

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	<u>5082073</u>
D2744	Cap	1 Ea (1 ea)	110-Skidtubes	<u>5060499</u>
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	<u>5102814</u>
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	<u>5122933</u>
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	<u>5080740</u>
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	<u>5107862</u>
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	<u>5095214</u>
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	<u>5049457</u>
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	<u>5006333</u>
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	<u>5090795</u>
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	<u>5091818</u>
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	<u>5092787</u>
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	<u>5107238</u>
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	<u>5107030</u>
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	<u>5097987</u>
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	<u>5115017</u>
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	<u>5097216</u>
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	<u>5058407</u>
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	<u>5098605</u>
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	<u>5089345</u>
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	<u>5089448</u> <u>150 25963</u>
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	<u>5108630</u>
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	<u>5099637</u>
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	<u>5058146</u>
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	<u>5090633</u>
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	<u>5089465</u>
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	<u>5076617-2</u>
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	<u>5083559</u>
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	<u>5106792</u>
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	<u>5057659</u>
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	<u>5058138</u>
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	<u>5099514</u>
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	<u>5068565</u>
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	<u>5125813</u>
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	<u>5090421</u>
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	<u>5083551</u>
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	<u>5089249</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	16	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																
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Past Expiry Date ☐	Manufacturing Process ☐																				
Misidentified ☐	Past Due ☐	OTHER : _____																			

110-Skidtubes	D2744	1	60	0
160-Skidtubes	D2739	1	37	0
	D2743	8	87	0
	D3490-1	4	203	0
	D3490-3	4	130	0
230-HandFinish	ALS4-1032-225	38	4,225	0
	AN3C5A	34	2,032	0
	AN3C6A	4	392	0
	AN6C44A	4	283	0
	AN8C35A	1	46	0
	D2745	8	85	0
	D3488-041	1	7	0
	D3492-1	8	248	0
	D3492-3	8	79	0
	D3535-25	1	43	0
	D3536-25	1	41	0
	D3537-1	3	209	0
	D3631-1	8	803	0
	D3791-1	1	37	0
	D3793-1	1	11	0
	D3793-3	1	11	0
	D3794-1	1	37	0
	D3794-3	1	43	0
	MS21043-6	4	244	0
	MS21083C8	1	133	0
	NAS1149C0332R	38	5,112	0
	NAS1149C0832R	1	438	0
	NAS1515H3L	4	635	0
	NAS1611-010	8	429	0
	NAS1611-013	8	1,325	0
250-Packaging	AN8C21A	2	106	0
	D2741	1	115	0
	D3493-1	2	27	0
	D3532-1	2	10	0
	MS21083C8	2	133	0
	NAS1149D0863J	2	77	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



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								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO. 180086 *11/5*
1806-29

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2013-08-13
WD

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY

REV. G
SHEET 1 OF 11
SCALE
NTS

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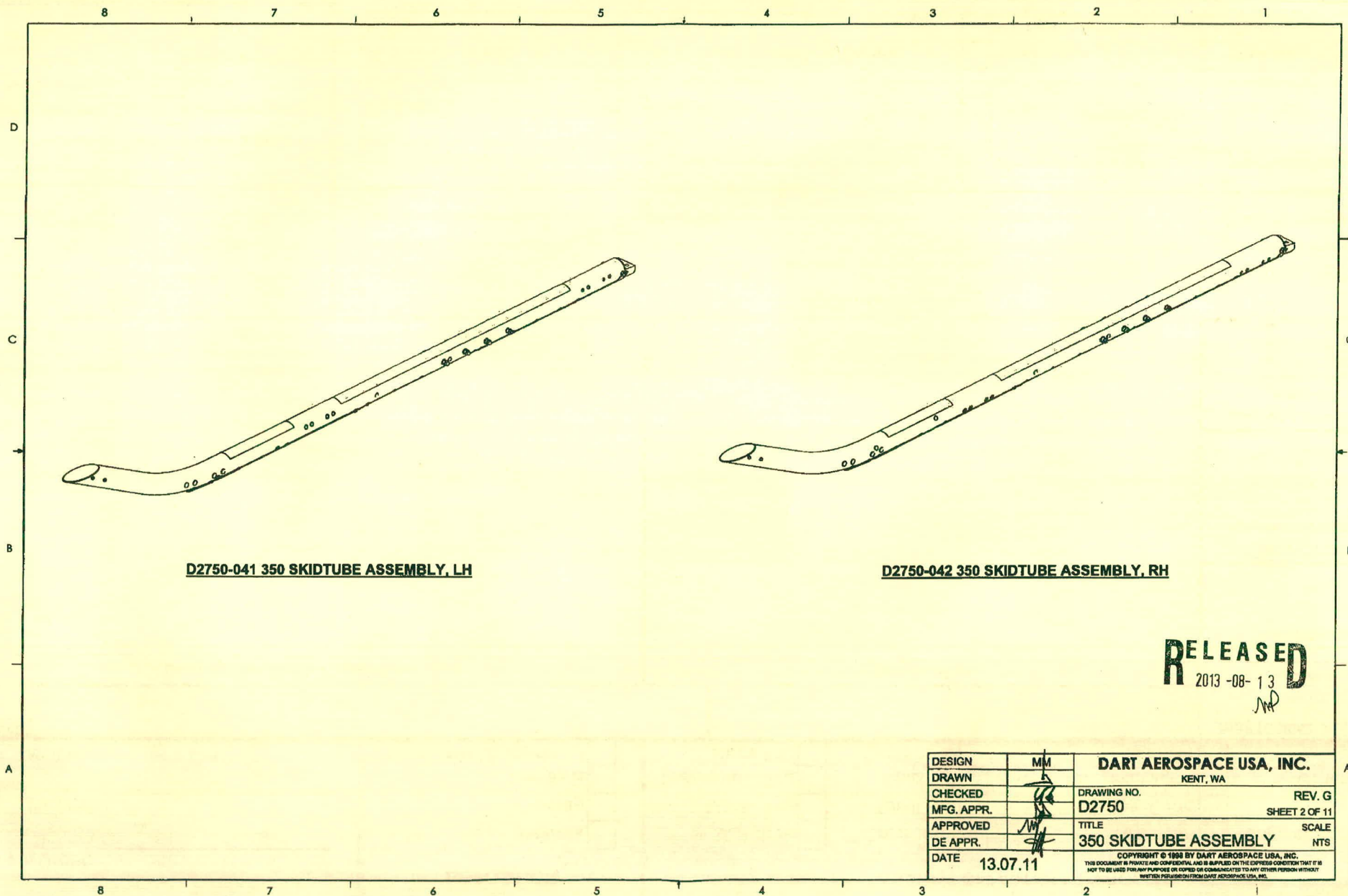


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



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DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		TITLE	SHEET 2 OF 11
APPROVED		350 SKIDTUBE ASSEMBLY	SCALE NTS
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DATE	13.07.11		

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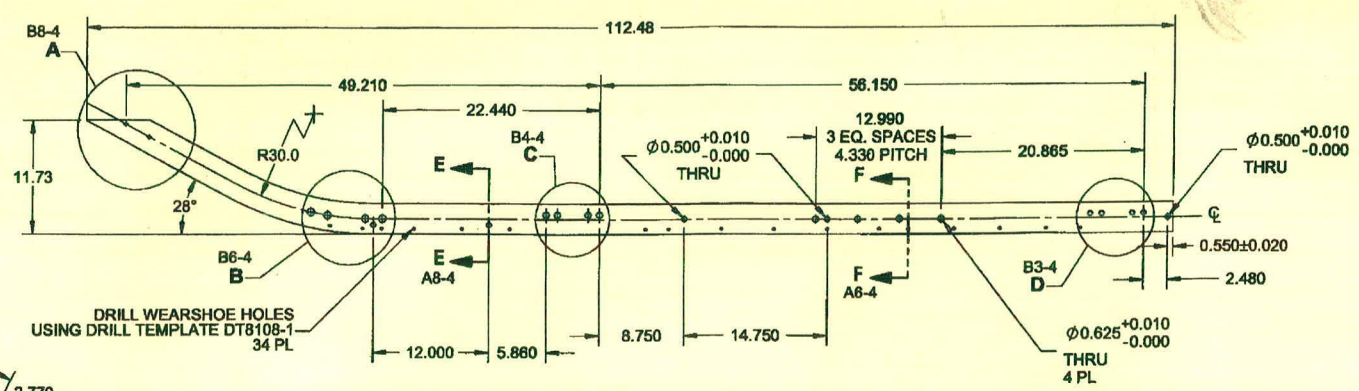


WORK ORDER NON-CONFORMANCE / UPDATE

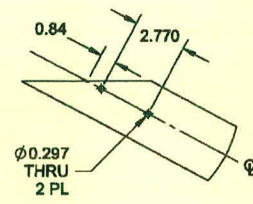
QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

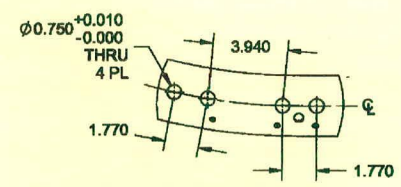
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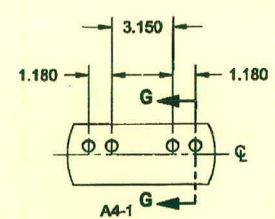
D2750-1 LH SKIDTUBE



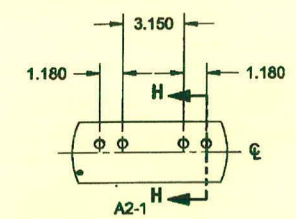
DETAIL A
SCALE 2X



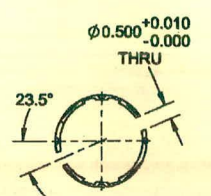
DETAIL B
SCALE 2X



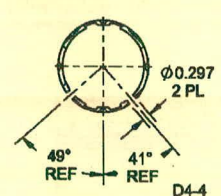
DETAIL C
SCALE 2X



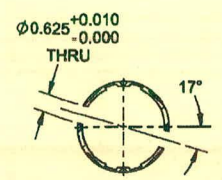
DETAIL D
SCALE 2X



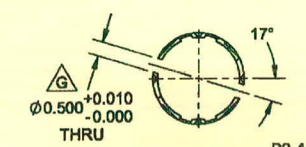
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____

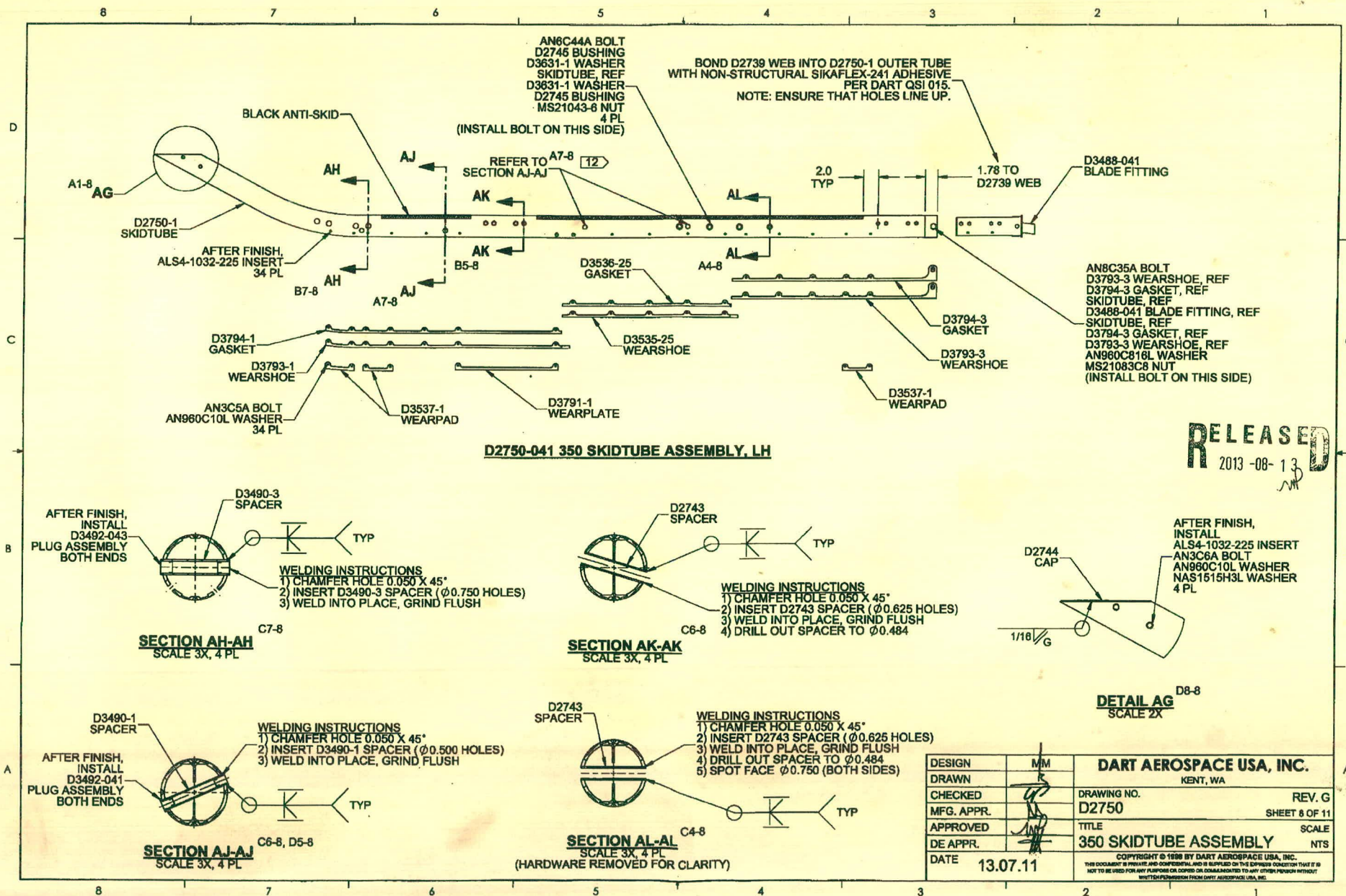


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							



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2013-08-13



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041604**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041604
PO Date: 11/6/18
Due Date: 11/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185414	D350-636-014	Skidtube RH, Std Wearplates, DART (Apical) Tri-Bag/Air Cruisers Float Comp. : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2	Firmed -		11/9/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
2	184226	D350-636-011	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____ Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp. : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08	Firmed -		11/9/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
184227				Firmed -		11/9/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
180086				Firmed -		11/9/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							3	0	3		\$675.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041604**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$900.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/6/18 8:25 AM dart.tsimiklis.chrisoula

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE
*23A	1	1	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*24A	1	1	1	1	1	1	1	D3793-5	WEARSHOE (REPLACES D3535-25)
*25A	1	1	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*26A	34	34	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	34	34	NAS1149C0332R	WASHER
*28	34	34	34	34	34	34	34	ALS4-1032-225	INSERT
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
50	2	2						D3532-1	SPACER
****97					1	1		AN3C34A	BOLT
****98					2	2		NAS1149CO363R	WASHER
****99					1	1		MS21043-3	NUT
100A							4	AN526C1032R10	SCREW
100B							4	AN526C1032R18	SCREW

* PART OF D2750-041/-042, D2750-043/-044 OR D2750-051/-052 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

***** PART OF D2750-051 OR D2750-052 ASSEMBLY

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Revision: K

Date: 18.04.04

REFERENCE ONLY

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5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149D0863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

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Revision: K
Date: 18.04.04

REFERENCE ONLY

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Change Record

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Part Number: D350-636-011/-011GB/-012/-012GB

Description: SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

[illegible]

